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CONFIDENTIAL*Destructor system  
File*

25X1

January 20, 1960

*Rec'd EP  
1/21/60**96  
Art Age*

Dear Sir:

As a part of the effort under Task Order No. Z, we have prepared a set of working drawings for the Type 2 Prototype Incinerator. Enclosed are the originals and one set of prints of these drawings. We have retained a set of reproducible foils and one set of prints for use in case we are called upon to assist you in your discussions with the fabricator.

During the development of the Type 2 Unit and the preparation of these drawings, we have found that 11 points should be watched particularly by the fabricator during the construction of this incinerator. These are listed below:

(1) The "V" Band Assembly shown on Drawing No. 354-110 was not detailed because it is a purchased part. Three weeks or more should be allowed for the delivery of this assembly.

(2) When the louvers are formed, particular care must be taken to have the louvers open in the proper direction and to deburr all of the louver edges. The parts involved are: Door Inner Liner (Drawing No. 354-343); Liner Upper Cone (Drawing No. 354-417); Bottom Cone (Drawing No. 354-416); Liner Lower Section (Drawing No. 354-415); and Liner Middle Section (Drawing No. 354-414).

(3) When the Basket Top Band (Drawing No. 354-327) is tack welded to the Liner Upper Cone (Drawing No. 354-417) in the Top Liner Assembly

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(8) When the two parts of the Flexible Duct (Drawing No. 354-434) are cemented together, the end of the Damper Housing Assembly (Drawing No. 354-209) should be used as a form.

(9) When the complete Inner Liner Assembly is inserted into the Outer Shell Assembly (see Item 10 below) with the Reflector Assembly installed as shown in Incinerator Assembly (Drawing No. 354-100), the notch in the Central Cone Base Ring (Drawing No. 354-413) on the Liner Bottom Section Assembly (Drawing No. 354-113) should be aligned with the proper end of the Stiffener (Drawing No. 354-301) on the Bottom Assembly Outer Shell (Drawing No. 354-103).

(10) It should be noted that the Inner Liner Assembly drawings (Nos. 354-104, 354-105, and 354-113) and the Outer Shell Assembly drawings (Nos. 354-101, 354-102, and 354-103) are marked with assembly reference lines to facilitate proper orientation during assembly.

(11) During final assembly when the Outer Shell Top Assembly (Drawing No. 354-101) is placed on the Outer Shell Middle Section (Drawing No. 354-102), care should be taken to avoid damaging the Seal Strip (Drawing No. 354-407) attached to the Top Liner Assembly (Drawing No. 354-104). To minimize difficulty, tape may be used to hold the Seal Strips in place during assembly.

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(Drawing No. 354-104), care should be taken not to warp the Liner Upper Cone or to allow gaps to occur between the Basket Top Band and the Liner Upper Cone.

(4) When the Stiffener (Drawing No. 354-301) and Stiffener (Drawing No. 354-302) are tack welded to the Base Plate (Drawing No. 354-300) in the Bottom Plate Assembly (Drawing No. 354-208), care should be taken not to warp the Base Plate.

(5) When the Radiation Shield (Drawing No. 354-391) is tack welded to the Stiffener (Drawing No. 354-301) and Stiffener (Drawing No. 354-302) in the Bottom Plate Assembly (Drawing No. 354-208), care should be taken not to burn holes in the Radiation Shield. Likewise, care should be taken not to burn holes in the Shield (Drawing No. 354-325) when it is tack welded to the Channel (Drawing No. 354-323) in the Door Channel Assembly (Drawing No. 354-204).

(6) When the Nozzle (Drawing No. 354-364) and the Nozzle (Drawing No. 354-333) are welded into the Liner Middle Section (Drawing No. 354-414) in the Liner Middle Section Assembly (Drawing No. 354-105), it is essential that the Nozzles be aligned as shown in the assembly drawing. The proper angularity of the Nozzles is critical and important to the proper air flow.

(7) When the Reflector Assembly (Drawing No. 354-109) is inserted into the Outer Shell Middle Assembly (Drawing No. 354-102) and the Bottom Assembly Outer Shell (Drawing No. 354-103) in the Incinerator Assembly (Drawing No. 354-100), the Reflector Assembly should be collapsed enough to pass by the Firing-Door inward projection.

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We would appreciate any comments that you or your associates might care to make with regard to the drawings or the above-described fabrication precautions.

Sincerely, ,



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ABW:th

In Triplicate

Enclosures

INCINERATOR ASSEMBLY PARTS LIST

| <u>Drawing No.</u> | <u>Description</u>             |
|--------------------|--------------------------------|
| 354-100            | Incinerator assembly           |
| 101                | Outer shell top assembly       |
| 102                | Outer shell middle assembly    |
| 103                | Bottom assembly outer shell    |
| 104                | Top liner assembly             |
| 105                | Liner middle section assembly  |
| 106                | Liner lower section assembly   |
| 107                | Liner bottom cone assembly     |
| 108                | Inner liner base cone assembly |
| 109                | Reflector assembly             |
| 110                | "V" band assembly              |
| 111                | Basket assembly                |
| 112                | Handle assembly                |
| 113                | Bottom liner section assembly  |
| 114                | Door assembly                  |
| 115                | Stack ring assembly            |
| 354-202            | Butterfly assembly             |
| 203                | Inspection door assembly       |
| 204                | Door channel assembly          |
| 205                | Door stiffener                 |
| 206                | Frame                          |
| 207                | Frame assembly                 |
| 208                | Bottom plate assembly          |
| 209                | Damper housing assembly        |

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| <u>Drawing No.</u> | <u>Description</u>               |
|--------------------|----------------------------------|
| 354-210            | Door liner                       |
| 211                | Duct assembly                    |
| 212                | Door frame assembly              |
| 213                | Firing door front panel assembly |
| 214                | Inspection door screw assembly   |
| 215                | Latch assembly                   |
| 216                | Handle weldment                  |
| 217                | Clamp band assembly              |
| 354-300            | Base plate                       |
| 301                | Stiffener                        |
| 302                | Stiffener                        |
| 303                | Side plate                       |
| 304                | Damper housing panel             |
| 305                | Bracket                          |
| 306                | Control plate                    |
| 307                | Duct side                        |
| 308                | Duct side                        |
| 309                | Duct panel                       |
| 310                | Duct panel                       |
| 311                | Duct flange                      |
| 312                | Damper blade                     |
| 313                | Damper center tube               |
| 314                | Damper shaft                     |
| 315                | Spacer                           |
| 316                | Collar                           |
| 317                | Stop                             |
| 318                | Screw                            |

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| <u>Drawing No.</u> | <u>Description</u>           |
|--------------------|------------------------------|
| 354-319            | Handle                       |
| 320                | Washer                       |
| 321                | Inspection door              |
| 322                | Gasket                       |
| 323                | Channel                      |
| 324                | Nut                          |
| 325                | Shield                       |
| 326                | Basket bottom                |
| 327                | Basket top band              |
| 328                | Hanger                       |
| 329                | Wedge                        |
| 330                | Corner fill                  |
| 331                | Door frame side              |
| 332                | Door frame top and bottom    |
| 333                | Nozzle                       |
| 334                | Nozzle                       |
| 335                | Nozzle                       |
| 336                | Bracket                      |
| 337                | Bracket                      |
| 338                | Washer                       |
| 339                | Spring retainer              |
| 354-340            | Pivot bar                    |
| 341                | Door stiffener               |
| 342                | Door stiffener               |
| 343                | Door inner liner             |
| 344                | Door <del>liner</del> flange |
| 345                | Door shield                  |

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| <u>Drawing No.</u> | <u>Description</u> |
|--------------------|--------------------|
| 354-346            | Door front         |
| 347                | Door basket        |
| 348                | Door gasket        |
| 349                | Washer             |
| 350                | Cotter pin         |
| 351                | Screw              |
| 352                | Nut                |
| 353                | Latch cam          |
| 354                | Latch handle       |
| 355                | Pivot block        |
| 356                | Link               |
| 357                | Screw              |
| 358                | Washer             |
| 359                | Cap screw          |
| 360                | Nut                |
| 361                | Cap screw          |
| 362                | Nut                |
| 363                | Hinged pin         |
| 364                | Nozzle             |
| 365                | Pivot bar          |
| 366                | Bracket            |
| 367                | Hinge              |
| 368                | Latch block        |
| 369                | Door frame         |
| 370                | Door frame         |
| 371                | Stiffener          |



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| <u>Drawing No.</u> | <u>Description</u> |
|--------------------|--------------------|
| 354-372            | Frame              |
| 373                | Frame              |
| 374                | Frame              |
| 375                | Handle             |
| 376                | Stiffener          |
| 377                | Grab rail          |
| 378                | Pivot angle        |
| 379                | Handle             |
| 380                | Handle hub         |
| 381                | Ball               |
| 382                | Slide              |
| 383                | Slide              |
| 384                | Spring             |
| 385                | Jam nut            |
| 386                | Cover              |
| 387                | Cover              |
| 388                | Screw              |
| 389                | Trigger rod        |
| 390                | Set screw          |
| 391                | Radiation shield   |
| 392                | Handle             |
| 393                | Screw              |
| 394                | Spring             |
| 395                | Spring             |
| 396                | Flange gasket      |
| 397                | Cap Screw          |
| 398                | Sight glass        |
| 399                | Gasket             |

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| <u>Drawing No.</u> | <u>Description</u>                                    |
|--------------------|---|
| 354-400            | Sight glass holder                                    |
| 401                | Sight glass nut                                       |
| 402                | Latch   |
| 403                | Nut   |
| 404                | Lock washer   |
| 405                | Spacer  |
| 406                | Central cone top section                              |
| 407                | Seal strip  |
| 408                | Basket  |
| 409                | Liner upper cone lower flange                         |
| 410                | Liner upper cone upper flange                         |
| 411                | Central cone <sup>middle</sup> <del>mid</del> section |
| 412                | Central cone bottom section                           |
| 413                | Central cone base ring                                |
| 414                | Liner middle section                                  |
| 415                | Liner lower section                                   |
| 416                | Liner bottom cone                                     |
| 417                | Liner upper cone                                      |
| 418                | Sight glass nipple                                    |
| 419                | Sight glass nipple                                    |
| 420                | Vent pipe ring  |
| 421                | Coupling flange                                       |
| 422                | Outer shell top ring                                  |
| 423                | Coupling flange                                       |
| 424                | Top ring outer shell                                  |
| 425                | Outer shell flange                                    |
| 426                | Outer shell top cone                                  |

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| <u>Drawing No.</u> | <u>Description</u>                           |
|--------------------|--|
| 354-427            | <del>Middle</del><br>Mid section outer shell |
| 428                | Bottom section outer shell                   |
| 429                | Inspection port ring                         |
| 430                | Reflector shield                             |
| 431                | Reflector shield                             |
| 432                | Reflector shield                             |
| 433                | Reflector shield                             |
| 434                | Flexible duct                                |
| 435                | Clamp  |
| 436                | Clamp band                                   |
| 437                | Blower                                       |
| 438                | Duct flange gasket                           |
| 439                | Cap screw                                    |
| 440                | Nut  |
| 441                | Lockwasher                                   |
| 442                | Clamp block                                  |
| 443                | Clamp block                                  |
| 444                | Set screw                                    |
| 445                | Lockwasher                                   |
| 446                | Lockwasher                                   |
| 447                | Nut  |
| 448                | Lockwasher                                   |

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